

# Process Sheet

|  |  |                              |                     |
|--|--|------------------------------|---------------------|
| Customer   | : CU-DAR001 Dart Helicopters Services  | Drawing Name                 | : 206B AFT X-TUBE   |
| Job Number   | : 36051  |                              |                     |
| Estimate Number  | : 12347  |                              |                     |
| P.O. Number  | : N/A  | Part Number                  | : D206667201        |
| This Issue   | : 11/29/2007   | S.O. No.                     | : N/A               |
| Prsht Rev.   | : NC   | Drawing Number               | : D206-667-241 REVB |
| First Issue  | : N/A  | Project Number               | : N/A               |
| Previous Run   | : 36050  | Drawing Revision             | : B                 |
|  |  | Material                     | : N/A               |
|  |  | Due Date                     | : 12/24/2007        |
| Written By   | : _____  | Qty:                         | 1 Um: Each          |
| Checked & Approved By  | : _____  |                              |                     |
| Comment  | : Est Rev: F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM |                              |                     |
| Additional Product   |  |                              |                     |
| Job Number: _____  |  |                              |                     |
| Seq. #:  | Machine Or Operation:  | Description :                | ①                   |
| 1.0  | DC   | DOCUMENT CONTROL             |                     |
|  |  |                              | KS 07.12.07         |
| Comment: DOCUMENT CONTROL  |  |                              |                     |
| Photocopy bluefile and create labels as per PPP D206-667-201 CHG002                      |  |                              |                     |
| 2.0  | D6003102   | Crosstube                    |                     |
|  |  |                              |                     |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)                                |  |                              |                     |
| Pick:  |  |                              |                     |
| Qty Part number Description Batch  |  |                              |                     |
| 1 D6003-102 Crosstube B23967   |  |                              |                     |
| Check OD = 2.250"; ID = 1.380"   |  |                              |                     |
| 3.0  | MORI SEIKI   | MORI SEIKI CNC LATHE LARGE   |                     |
|  |  |                              |                     |
| Comment: MORI SEIKI CNC LATHE LARGE  |  |                              |                     |
| 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084             |  |                              |                     |
| 2-Turn first side as per Folio FA084   |  |                              |                     |
| 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-1 |  |                              |                     |
| 4.0  | QC1  | INSPECT ALL DIM TO DIM SHEET |                     |
|  |  |                              |                     |
| Comment: INSPECT ALL DIM TO DIM SHEET  |  |                              |                     |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:08:15 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 36051

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA084

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241

Inside of Cuff(Donot engrave on outside of tube)

*SG 07.12.05* (U)

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*SG 07.12.05* (U)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*SG 07.12.05* (U)

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

*AWM 07-12-05*

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*DD 7-12-5*

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*AWM 07-12-05*

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-241 using CNC bender program 206B-AF and Folio FT

*EL 7-12-6*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:08:15 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 36051

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



11-12-06 @



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

2-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576.  
(DRILL 3 HOLES ON BOTH SIDES)

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate tube using "T" pins off holes drilled in previous step.

4-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

5-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. Check dimensions between holes on all four sides to ensure proper alignment. Use DT8583 & 8584 SUPPORT Jigs.  
(DRILL 3 HOLES ON BOTH SIDES)

6-Drill rivet holes as per Dwg D206-667-241 using drill Jig DT8788

7-C'sink holes as per Dwg D206-667-241

8-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241

SR/BL  
7-12-06

07-12-10 AWM

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



07-12-10 AWM



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-13

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-12-13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:08:15 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 36051

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: ~~5299X~~

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

7/10: 5362 C208/01/04 ①

C207/12/17 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

C208/02/04  
C207/12/17 ①

P10

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage &amp; ensure results are as per Dwg D206-667-103

C208/01/04 ①

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes .

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

25 08-01-09

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

C208/01/16

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

35900

25 08-01-12

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 09/10/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)   |                                |   |                             |                                |                                |                                |
|----------|------|--|--------------------------------|---|-----------------------------|--------------------------------|--------------------------------|--------------------------------|
| DATE     | STEP | Description of NC<br>Section A   | Corrective Action Section B    |   |                             | Verification<br>Section C      | Approval<br>Chief Eng          | Approval<br>QC Inspector       |
|          |      |  | Initial<br>Chief Eng           | Action Description<br>Chief Eng   | Sign &<br>Date              |                                |                                |                                |
| 07-12-18 | 17.0 | Some deep / un-finished grinding marks were Apparent during VDT/LPI.<br><br>R.C. Tube was not properly polished well enough. | <i>[Signature]</i><br>08/01/18 | re-polish entire tube, and ensure a smooth surface, LPI to the next visit.<br>* See last page NDI results * | AWM<br>07-12-20<br>08/01/07 | <i>[Signature]</i><br>08/01/07 | <i>[Signature]</i><br>08/01/18 | <i>[Signature]</i><br>07-12-18 |
|          |      |  |                                |   |                             |                                |                                |                                |
|          |      |  |                                |   |                             |                                |                                |                                |

NOTE: Date & initial all entries



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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 36051

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

34062

25

08-01-12

24.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

103478

25 08-01-12

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579.

2-Install supports and clamps as per Dwg D206-667-241. Torque clamps to 80-100 in lb

25 08-01-12

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

25 08/01/16 (2)

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M105408

25 08/01/16 (2)

29.0

D2872043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2872-043

Nut Plate

1328918

25 08/01/16 (2)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:08:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 36051

Part Number: D206667201

Job Number:



| Seq. # | Machine Or Operation: | Description : |
|--------|-----------------------|---------------|
|--------|-----------------------|---------------|

|      |          |                    |
|------|----------|--------------------|
| 30.0 | D2872045 | Nut Plate Assembly |
|------|----------|--------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2872-045 Nut Plate B 28919

AS 08/01/16

(X)

|      |        |      |
|------|--------|------|
| 31.0 | AN510A | Bolt |
|------|--------|------|



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

10 AN5-10A Bolt M104746

AS 08/01/16

(X)

|      |        |      |
|------|--------|------|
| 32.0 | AN530A | BOLT |
|------|--------|------|



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

10 AN5-30A Bolt M105144

AS 08/01/16

(X)

|      |            |        |
|------|------------|--------|
| 33.0 | AN960JD516 | Washer |
|------|------------|--------|



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

20 AN960JD516 Washer M106167

AS 08/01/16

(X)

|      |           |     |
|------|-----------|-----|
| 34.0 | MS21042L5 | Nut |
|------|-----------|-----|



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

10 MS21042L5 NUT M105940

AS 08/01/16

(X)

|      |     |                                    |
|------|-----|------------------------------------|
| 35.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
|------|-----|------------------------------------|



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/16 (X)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Drawing Name: 206B AFT X-TUBE

Job Number: 36051

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-201

Location: B

PPP Rev: 8/1/17

scr

(12)

37.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

206667201/18

Job Completion



206667201/17  
ru

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|  |  |                     |              |
|--|--|---------------------|--------------|
| <b>DART AEROSPACE LTD</b>              |  | <b>Work Order:</b>  | 36051        |
| <b>Description:</b> Crosstube Assembly |  | <b>Part Number:</b> | D206-667-241 |
| Inspection Dwg: D206-667-241 Rev: B    |  | Page 1 of 1         |              |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Inspection Sheet<br>Drawing Dimension |             | Tolerance     | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|-------------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A                                | 30° x 0.500 | +/-0.010      | 500                 | ✓      |        |                         |          |
|                                       | 0.250       | +/-0.010      | 250                 | ✓      |        |                         |          |
|                                       | 2.240       | +0.005/-0.000 | 2.243               | ✓      |        |                         |          |
|                                       | 4.438       | +/-0.030      | 4.438               | ✓      |        |                         |          |
|                                       | 1.780       | +0.005/-0.000 | 1.785               | ✓      |        |                         |          |
|                                       | R0.063      | +/-0.010      | 063                 | ✓      |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       | 1.851       | +0.005/-0.000 | 1.855               | ✓      |        |                         |          |
|                                       | 1.928       | +0.005/-0.000 | 1.932               | ✓      |        |                         |          |
|                                       | 2.005       | +0.005/-0.000 | 2.009               | ✓      |        |                         |          |
|                                       | 2.082       | +0.005/-0.000 | 2.085               | ✓      |        |                         |          |
|                                       | 2.159       | +0.005/-0.000 | 2.162               | ✓      |        |                         |          |
|                                       | 2.190       | +0.005/-0.000 | 2.193               | ✓      |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
| SIDE B                                | 30° x 0.500 | +/-0.010      | 500                 | ✓      |        |                         |          |
|                                       | 0.250       | +/-0.010      | 250                 | ✓      |        |                         |          |
|                                       | 2.240       | +0.005/-0.000 | 2.243               | ✓      |        |                         |          |
|                                       | 4.438       | +/-0.030      | 4.438               | ✓      |        |                         |          |
|                                       | 1.780       | +0.005/-0.000 | 1.784               | ✓      |        |                         |          |
|                                       | R0.063      | +/-0.010      | 063                 | ✓      |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       | 1.851       | +0.005/-0.000 | 1.855               | ✓      |        |                         |          |
|                                       | 1.928       | +0.005/-0.000 | 1.932               | ✓      |        |                         |          |
|                                       | 2.005       | +0.005/-0.000 | 2.008               | ✓      |        |                         |          |
|                                       | 2.082       | +0.005/-0.000 | 2.084               | ✓      |        |                         |          |
|                                       | 2.159       | +0.005/-0.000 | 2.163               | ✓      |        |                         |          |
|                                       | 2.190       | +0.005/-0.000 | 2.193               | ✓      |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       | 100.60      | +/-0.020      | 100.62              | ✓      |        |                         |          |

|                     |          |                    |          |                            |     |
|---------------------|----------|--------------------|----------|----------------------------|-----|
| <b>Measured by:</b> | BG       | <b>Audited by:</b> | Imp      | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>        | 07.12.04 | <b>Date:</b>       | 07/12/05 | <b>Date:</b>               | N/A |

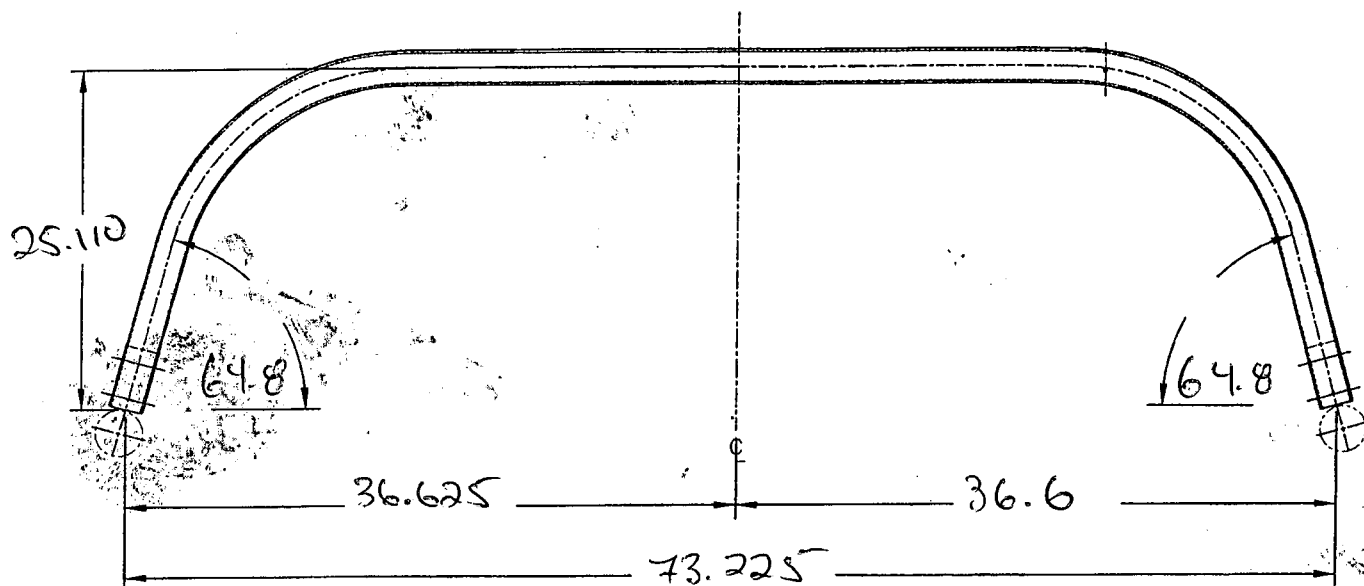
| Rev | Date     | Change                       | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A   | 06.10.16 | New Issue (P/O D206-667-201) | KJ/JLM     | B        |





|   |  |                     |              |
|---|--|---------------------|--------------|
| <b>DART AEROSPACE LTD</b>                         |  | <b>Work Order:</b>  | 36051        |
| <b>Description:</b> Crosstube High Aft (206B)     |  | <b>Part Number:</b> | D206-667-201 |
| <b>Inspection Dwg:</b> D206-667-241 <b>Rev:</b> B |  | <b>Page 1 of 1</b>  |              |

| Required Dimension | Min   | Max   |
|--------------------|-------|-------|
| Height             | 24.98 | 25.10 |
| 1/2 Span           | 36.54 | 36.66 |
| Angle              | 65    | 67    |
| Total Span         | 73.08 | 73.32 |



| Comments |
|----------|
|          |
|          |
|          |
|          |
|          |

|                 |                    |
|-----------------|--------------------|
| QC15 Inspection | <i>[Signature]</i> |
| Date            |                    |

| Rev | Date     | Change    | Revised by               | Approved           |
|-----|----------|-----------|--------------------------|--------------------|
| A   | 07.02.06 | New Issue | KJ/JM <i>[Signature]</i> | <i>[Signature]</i> |



|                        |                         |  |                        |
|------------------------|-------------------------|--|------------------------|
| DESIGN<br>PH           | DRAWN BY<br>PH          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA    |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D206-667-241                          | REV. B<br>SHEET 1 OF 3 |
| DATE<br>05.02.04       |                         | TITLE<br>CROSSTUBE ASS'Y (206B HIGH AFT)             | SCALE<br>NTS           |
| A                      | 00.11.17                | NEW ISSUE  |                        |
| B                      | 05.02.04                | ADD HOLES FOR COMPATABILITY WITH<br>BHT/AA SKIDTUBES |                        |

RELEASED  
05-06-16 [Signature]

| Qty | Part Number   | Description                        |
|-----|---------------|------------------------------------|
| X   | D206-667-241  | CROSSTUBE ASSEMBLY (206B HIGH AFT) |
| 1   | D6003-102     | CROSSTUBE                          |
| 2   | D2856-400-694 | ABRASION STRIP                     |
| 2   | D2891-1       | SUPPORT                            |
| 4   | MS21920-20    | CLAMP                              |

#### GENERAL NOTES:

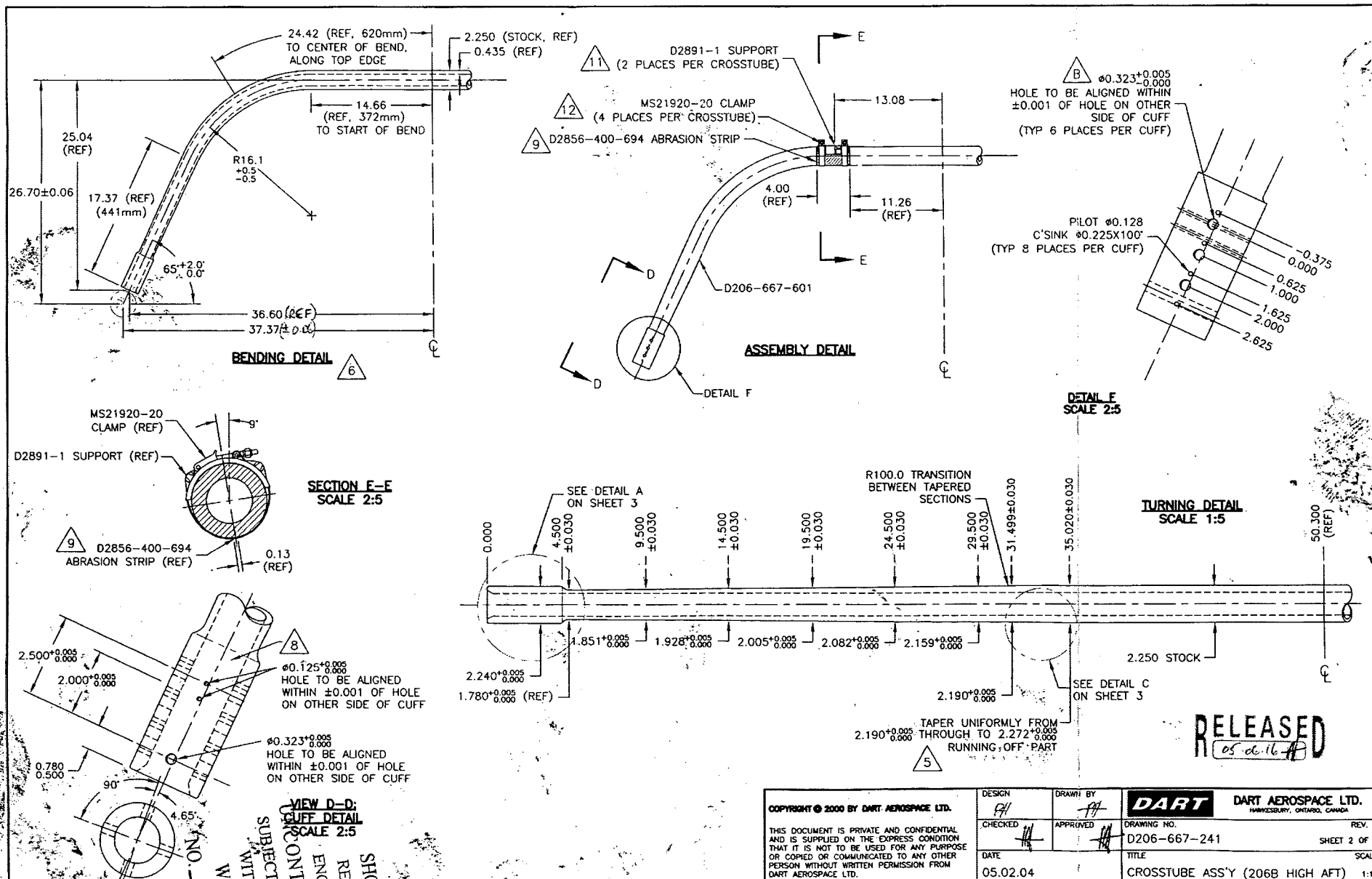
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6003-102  
FINISHED LENGTH =  $100.60 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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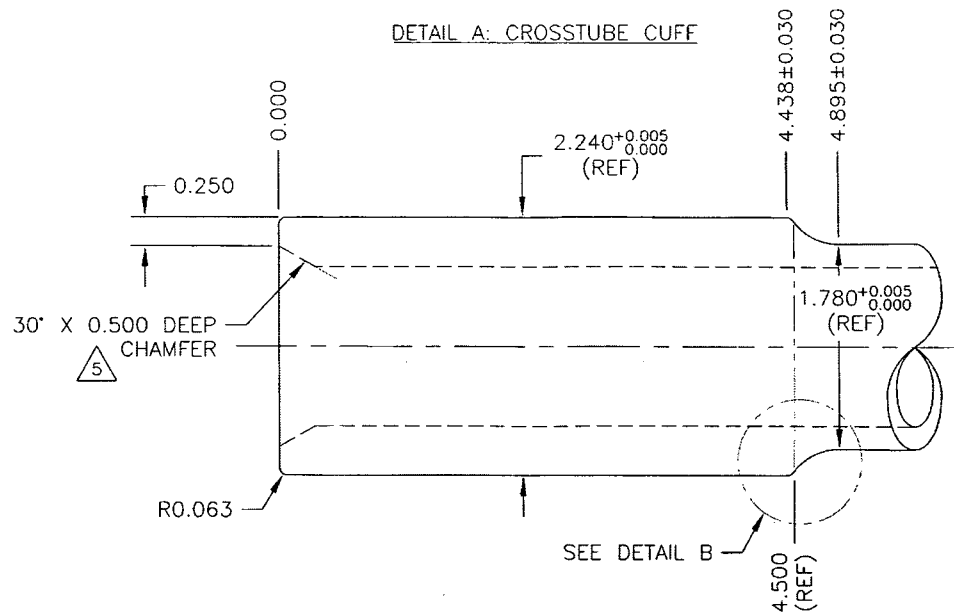
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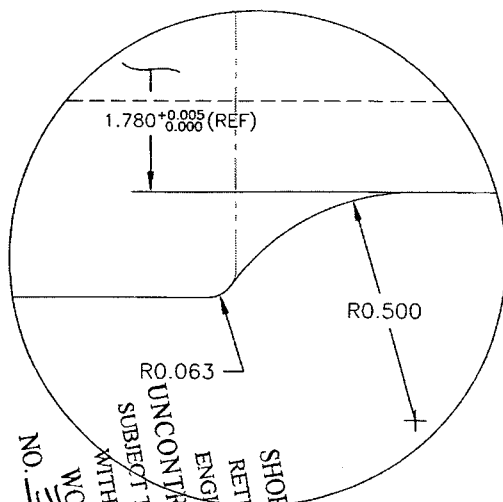


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05-06-16

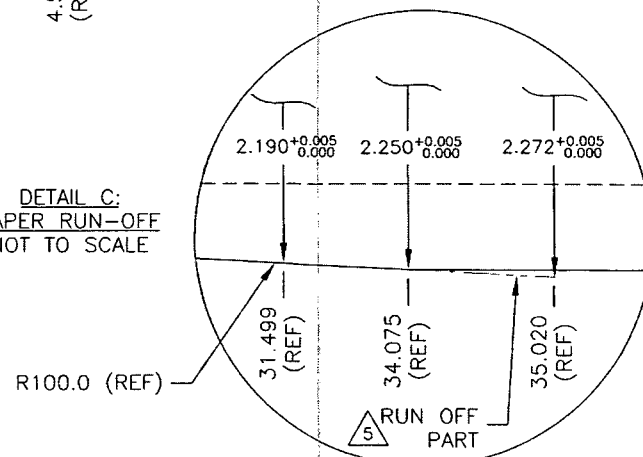
DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1



DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



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|                  |  |                             |  |
|------------------|--|-----------------------------|--|
| DESIGN<br>PH     | DRAWN BY<br>PH                           | <b>DART</b>                 | DART AEROSPACE LTD.<br>MARKESBURY, ONTARIO, CANADA |
| CHECKED<br>#     | APPROVED<br>#                            | DRAWING NO.<br>D206-667-241 | REV. B<br>SHEET 3 OF 3                             |
| DATE<br>05.02.04 | TITLE<br>CROSSTUBE ASS'Y (206B HIGH AFT) | SCALE<br>1:1                |  |





# LIQUID PENETRANT TEST REPORT

P - 7-1055

|                  |  |                 |                   |           |                             |                             |   |
|------------------|--|-----------------|-------------------|-----------|-----------------------------|-----------------------------|---|
| CLIENT           | DART AREOSPACE   | DATE            | DEC. 14, 2007     | PAGE      | 1                           | OF                          | 1 |
| ATTENTION        | LINDA LACELLE  | ACUREN JOB NO.  | 188-7-01055       | TIME      | AM <input type="checkbox"/> | PM <input type="checkbox"/> |   |
| ADDRESS          | 1270 ABERDEEN ST. HAWKESBURY ONT.  | PO/NO.          |                   |           |                             |                             |   |
|                  |  | WORK LOCATION   | HAWKESBURY        |           |                             |                             |   |
|                  |  | ACCEPTANCE STD. | ASTM 1417/QSI-038 | REV./DATE | 2005                        |                             |   |
| PROJECT          | 212/205 HIGH FED X-TUBE, 206L FWD X-TUBES, 206BAFT X-TUBES, 206L AFT X-TUBES |                 |                   |           |                             |                             |   |
| ITEM(S) EXAMINED | JOB #'S 35725, 35893, 36051, 36053, 36055, 36056, 36057, 36059,              |                 |                   |           |                             |                             |   |

|                 |  |           |                          |           |
|-----------------|--|-----------|--------------------------|-----------|
| JOB DESCRIPTION | PROCEDURE NO. LT-0002  | REV./DATE | TECHNIQUE NO. LT-0002-02 | REV./DATE |
| Part No.        | D206667201, D206667203, D212664101, D206667103                                       | Material  | ALODYNED ALUMINUM        | Thickness |
| Scope           | WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE. |           |                          |           |

## TEST DETAILS

|                   |   |                                  |  |  |   |
|-------------------|---|----------------------------------|--|--|---|
| Method            | <input checked="" type="checkbox"/> Fluorescent | <input type="checkbox"/> Visible | <input checked="" type="checkbox"/> Water Wash | <input type="checkbox"/> Solvent Removable | <input type="checkbox"/> Post Emulsified                                  |
| Family Brand      | MAGNAFLUX                                       |                                  | Black Light S/N                                | 8178                                       | <input checked="" type="checkbox"/> Output > 1000 $\mu$ W/cm <sup>2</sup> |
| Penetrant         | ZL67  | Minimum Dwell time               | 45   | Min.                                       | <input checked="" type="checkbox"/> Ambient < 2 fc                        |
| Penetrant Remover | H20   | Minimum Dry time                 | >10  | Min.                                       | <input checked="" type="checkbox"/> Output > 100 fc @ surface             |
| Developer         | SKDS2   | Minimum Dwell time               | 10   | Min.                                       |   |
| Developer Type    | <input checked="" type="checkbox"/> Non Aqueous | <input type="checkbox"/> Aqueous | <input type="checkbox"/> Dry                   |  | Cal Due Date MAR 08   |

## TEST SURFACE

|                     |   |   |   |                                       |   |
|---------------------|---|---|---|---------------------------------------|---|
| Surface Condition   | <input checked="" type="checkbox"/> As Ground | <input type="checkbox"/> As Welded                | <input checked="" type="checkbox"/> Machined                | <input type="checkbox"/> Shot Blasted | <input type="checkbox"/> Clean Bare Metal |
| Surface Temperature | <input type="checkbox"/> < - 4°C/ 20°F        | <input type="checkbox"/> - 4°C/ 20°F to 10°C/50°F | <input checked="" type="checkbox"/> 10°C/50°F to 52°C/125°F | <input type="checkbox"/> > 52°C/125°F |   |

## RESULTS- ( ☐ METRIC ☐ IMPERIAL )

| item | Comments  | Accept | Reject |
|------|---|--------|--------|
|      | F.L.P.I. CARRIED OUT ON 100% OF EXTERNAL SURFACE OF: 212/205 HIGH FED X-TUBES JOB# 35893                |        |        |
|      | 206B AFT X-TUBES JOB #'S 36051, 35725   |        |        |
|      | 206L FWD X-TUBES JOB#'S 36053, 36055  |        |        |
|      | 206L AFT X-TUBES JOB #'S 36057, 36059, 36056  |        |        |
|      | RESULTS: 206B AFT X-TUBE #36051 HAS ROUGH GRINDING MARKS. TO BE POLISHED AND RECHECKED AT A LATER DATE. |        |        |
|      | ALL OTHER JOB #'S ARE ACCEPTABLE TO ASTM 1417/ QSI-038 STANDARD.  |        |        |

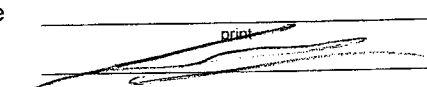
### Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

### Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

|                         |   |                         |
|-------------------------|---|-------------------------|
| Client Representative   |   | DTR #                   |
| Technician (Signature): |  | Report Reviewed by:     |
| Name (Print):           | FREDERICK CHAGNON   | Name initials           |
|                         | 1 <sup>st</sup> technician  |                         |
| CGSB Level              | II SNT Level  | CGSB Level II SNT Level |
| CGSB Reg. No            | 10560   | CGSB Reg. No 12247      |
|                         | 2 <sup>nd</sup> technician  |                         |

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**P - 8-1202**